

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001457**Date Inspected:** 05-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sha Zhi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

This Quality Assurance (QA) Inspector observed various fabrication and welding practices at Zhenhua Port Machinery Company (ZPMC) on Changxing Island in Shanghai, China today for the Self Anchored Suspension Bridge for San Francisco, California.

Orthotropic Box Girder (OBG)

This QA Inspector observed in Bay 1 the drilling of flange bolt holes on the flat closed u-rib plates and milling & machine beveling of flat closed u-rib plates for the partial joint penetration (PJP) and the machining of the 2 millimeter radius on hand access holes. Welding of the complete joint penetration (CJP) splice weld for deck plate DP049 PL120 was being carried out.

In Bay 1 the flatness of the bolted flange sections at both ends and sides of the closed u-ribs on Deck Plate DP058 PL14B were checked using a 1000 millimeter straight edge and a gap rule. Readings were taken just above the tack welded PJP weld, at the middle line of bolt holes and above the top row of bolt holes at the upper flange edge. A simple spreadsheet was made out containing the data and turned over to the Structural Material Representative (SMR) Mr. Adi Velasco. QA Inspector Paul Dawson assisted in the collecting of this data.

This QA Inspector assisted QA Inspectors Alfredo Acuna and Larry Viars in the mapping of transverse magnetic particle indications in fillet welds on the floor beams in Bay 7 under the direction of Island Structural Material Representative Adi Velasco.

WELDING INSPECTION REPORT

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Summary of Conversations:

No conversation held today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Berger,Bruce	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
